

Work Order ID 60851

Monday, July 26, 2010 10:42:40 AM

Page 1

Item ID: D3235-1

Accept

Revision ID:

Item Name: Mounting Lug

Start Date: 7/26/2010 Start Qty: 40.00

Required Date: 8/3/2010 Req'd Qty: 40.00

Reference:

Approvals:

Process Plan:

Date: 10-7-26

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3235

Rev A

100

0.00



Bandsaw

BAND SAW

Memo

Cut D2423 extrusion to 0.820"

Batch: 45800

0.00

aml 10/07/27

40

Ø

110

0.00



HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine as per Folio FA369 and Dwg D3235

2-Identify as D3235-1

3-Deburr

0.00

aml 10/08/02

SS 10/08/03

40

Ø

120

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

aml 10/08/02

40

Ø

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60851

Monday, July 26, 2010 10:42:40 AM

Page 2

Item ID: D3235-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Mounting Lug

Start Date: 7/26/2010 Start Qty: 40.00

Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 40.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

JTP 10/08/05

40

Ø

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

ml

10

08

09

40

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 2:00pm
OVEN TEMPERATURE: 320°F
FINISH TIME: 2:30pm

JTP

10/08/10

40

Ø

W/O:		WORK ORDER CHANGES					
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Work Order ID 60851

Monday, July 26, 2010 10:42:40 AM



Page 3

Item ID: D3235-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 7/26/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/8/18 90x

180

Identify as per dwg & Stock Location: ST 471

0.00



Packaging

Memo

0.00

Packaging

10/08/18

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/19
CL101818

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Monday, July 26, 2010 10:42:44 AM

Page 1

Work Order ID: 60851

Parent Item: D3235-1

Parent Item Name: Mounting Lug





Start Date: 7/26/2010

Required Date: 8/3/2010

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP ☐ A ☐ 04.04.19 ☐ New issue ☐ KJ/JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3235-1P 		Purchased	No			100	Each	0.0000	1	40			
lug													
D2423 		Manufactured	No			110	f	393.6932	0.0683	2.875789			
Lug Extrusion													

N/A .C.21081B

Location

MAT06

43722

→ 45800

Loc Qty

393.6931695

180

213.693169

Loc Code

2.875 *only*
10/07/27

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DART AEROSPACE LTD		Work Order:	60851
Description: Mounting Lug		Part Number:	D3235-1
Inspection Dwg: D3235 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.450	+/-0.010	4.453	—			
0.306	+/-0.010	.305	—			
1.85	+/-0.030	1.846	—			
R1.20	+/-0.010	R1.200	—			
R0.125	+/-0.010	R.125	—			
0.400	+/-0.010	.400	—			
0.735	+/-0.030	.726	—			
Ø0.505	+0.005/-0.000	Ø.507	—			
R0.38	+/-0.030	R.380	—			
3.700	+/-0.005	3.700	—			
0.375	+/-0.010	.375	—			
0.750	+/-0.010	.751	—			
Ø0.257	+0.005/-0.000	Ø.257	—			
R0.380	+/-0.030	R.380	—			

Measured by:	<i>Amf</i>	Audited by:	<i>DJP</i>	Prototype Approval:	N/A
Date:	10/08/02	Date:	10/08/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	<i>[Signature]</i>

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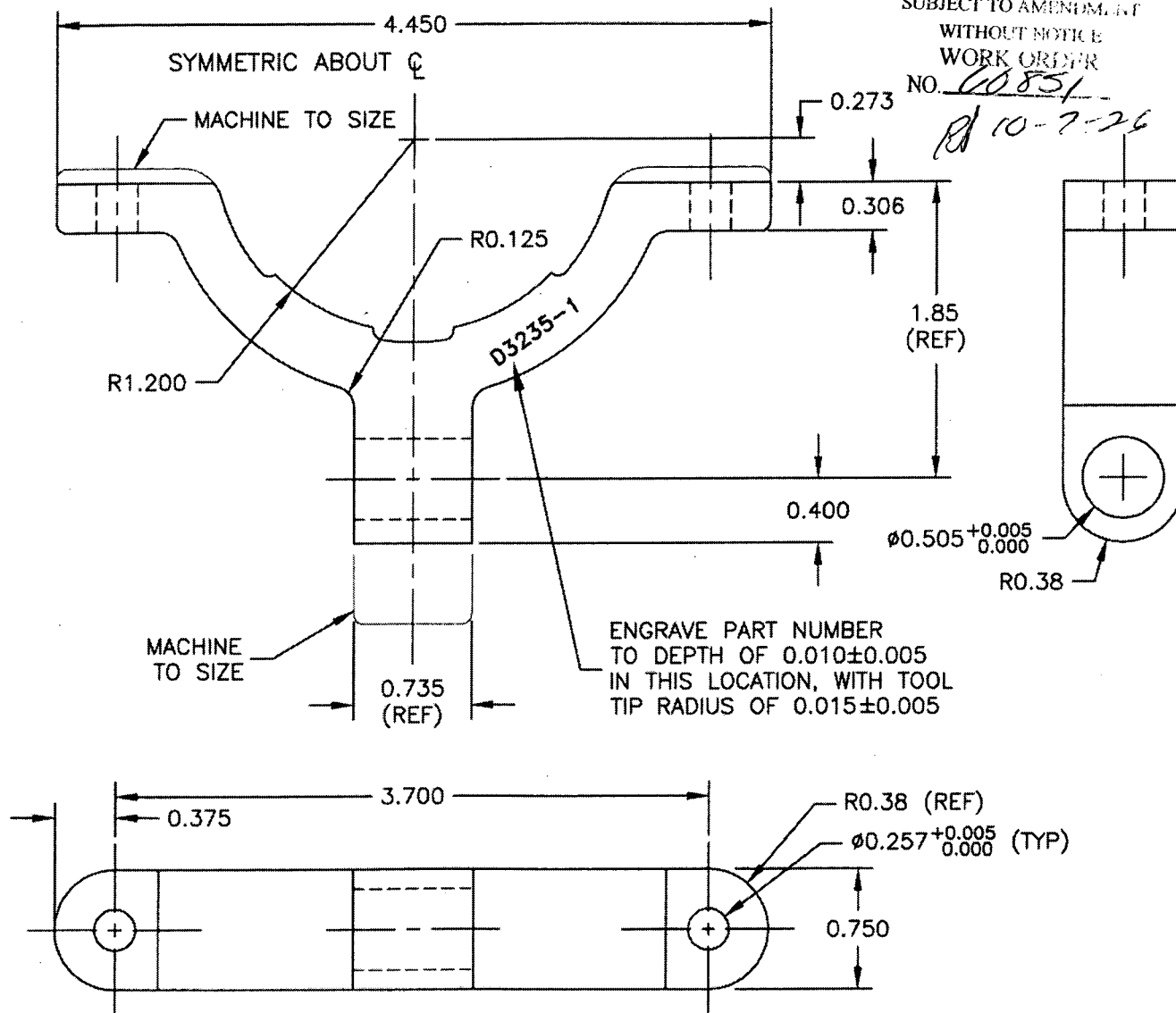


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3235	REV. A SHEET 1 OF 1
DATE 04.03.02		TITLE MOUNTING LUG	SCALE 1:1
A	04.03.02	NEW ISSUE	SHOP COPY

RELEASED
040405

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *60851*

10-7-26



D3235-1 MOUNTING LUG

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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